

Work Order ID 70201

Tuesday, May 31, 2011 10:48:45 AM



Page 1

Item ID: D4055-11

Accept



Setup Start



Revision ID:

Stop



Item Name: Tank Front and Bottom

Start Date: 5/31/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

*MM*Date: *11-05-31*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4055

*A B E**11.06.01*

100

0.00



Purchasing

Memo

0.00

Purchasing

Issue P/O: *14219*
Purchase part as per Dwg D4055
Possible Supplier: GFI
Material release note required*CL 11/06/01 (6)*

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

CL 11/06/22 (6)

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

*8 11/06/22**(6)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

11.06.22

Memo

0.00

6

0

Hand Finishing

140



QC

QC3- Inspect Part Finish

0.00

SAD 11-06-22

Memo

0.00

(6)

Quality Control

150



Packaging

Identify as per dwg & Stock Location: *W19*

0.00

Memo

0.00

11.06.22

6

0

Packaging

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/23

MF

11-06-23

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



Tuesday, May 31, 2011 10:48:42 AM

Page 1

[illegible]

Required Qty: 6.00

Comments: IPP RevA: new issue DD 10.01.08 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4055-11P  Tank Front and Bottom		Purchased	No			110	Each	0.0000	1 	6		CL11/06/22	

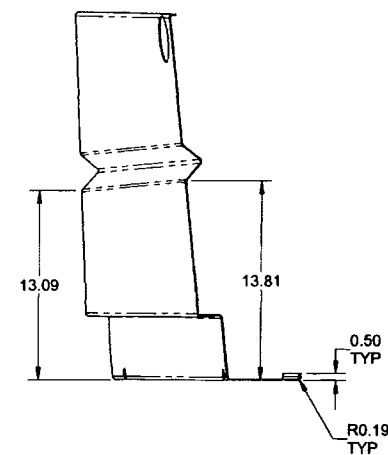
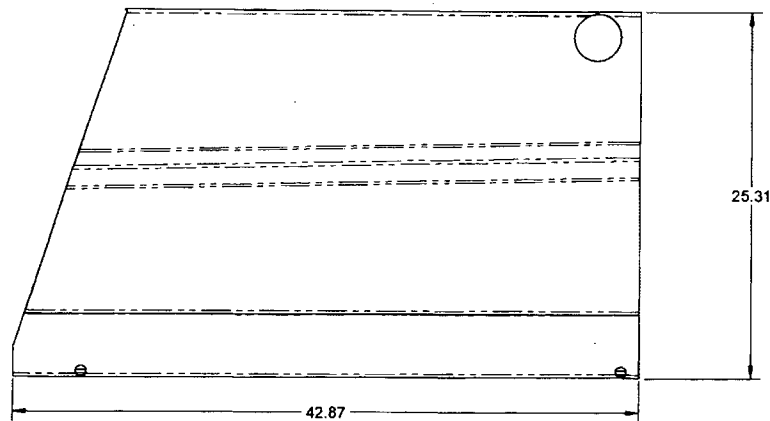
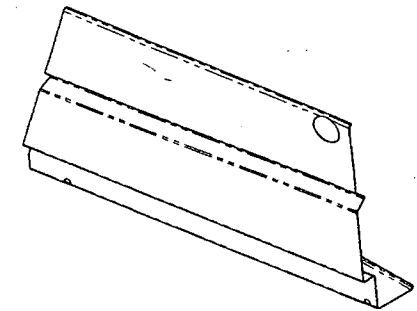
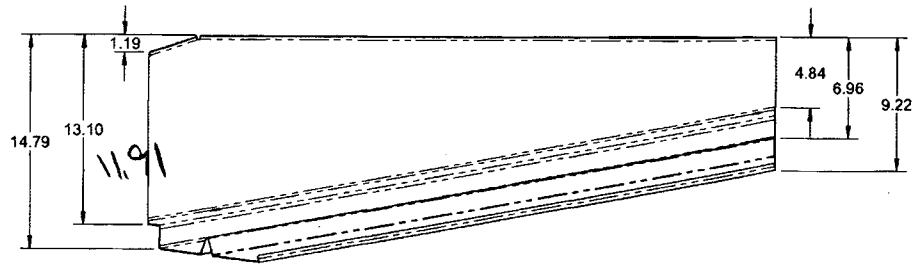
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NOTE: Date & initial all entries



D4055-11 TANK FRONT AND BOTTOM

NOTES:

- 1) MATERIAL: MADE FROM D4055-11F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.32 lbs



DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4055	REV. B
MFG. APPR.		TITLE	SHEET 14 OF 15
APPROVED		TANK	SCALE
DE APPR.			NTS
DATE	11.05.12	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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180 AVENUE LABROSSE
POINTE-CLAIRE, QC, CANADA H9R 1A1
TÉL.:(514) 630-4877 - FAX:(514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE			N° DE BON DE LIVRAISON / SHIPPING MEMO NO.		PAGE
JR - DY	MO - MO	AN - YR			
20	06	11	0464505		1/1



VENDU À / SOLD TO

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A. 1K7

CODE DE CLIENT / CUSTOMER CODE	N° DE CONTRAT / JOB NO.	VOTRE N° DE COMMANDE / YOUR PURCHASE ORDER NO.	EXPÉDIÉ PAR / SHIP VIA
DART GFI-0299	0232535	PO14219	

QUANTITÉ / QUANTITY	N° DE PIÈCE / PART NO.	DESCRIPTION
6	D4055-11P ✓ <i>CD 11106122</i>	TANK FRONT AND BOTTOM ITEM 1 C OF C REQ'D
MFG. JOB# <u>J0232535-001 QTY 6</u>		

EXPÉDITEUR / SHIPPER	N° DE BON DE LIVRAISON / SHIPPING MEMO NO.



REÇU PAR / RECEIVED BY

DATE

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO.	5	OUR JOB NO	J0232535	SHIPPING MEMO	0464505	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
---	6 PCS	PO14219	D4055-11P	B	TANK FRONT AND BOTTOM	B
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
.063 THK AL 6061-T6 (AMS-QQ-A250/11)		SAMUEL / ALCOA INC		517443		

	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	N/A
2	REF. GFI MANUFACTURING JOB NUMBER J0232535-001 (6 PCS)		
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 20 JUNE 2011

G.F.I. Q.C. REP.

B. Samer





Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2008 + AS9100B

LETTRE DE CONFORMITÉ - LETTER OF COMPLIANCE

Date: June 20, 2011

Company Name: GFI Division of Thomas & Betts limited
Address: 180 avenue Labrosse
City: Pointe-Claire Qc
Zip Code: H9R 1A1

du client: 0078622
Customer's order #:

de commande SSMQ: 439702
SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Guage/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
01	2	.063" X 48" X 144"	6061 T6	AMS-QQ-A-250/11 AMS 4027	517443

Bien à vous,
Yours truly,



CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS
Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.
Per:

Malcolm Murphy
Director of Manufacturing Davenport Works

Kanton P. Young
Quality Assurance Manager

1216348 0
Ship Date B.L. No. Invoice No. Alcoa No. Item Page 1
2011-03-02 5721205 00000 1000261613-3 DCE-61613-3
P.O. No./Govt Contract No. Customer Alcoa Item
C63283 Ln#: 3 SAMUEL SON & CO LT G041015421R12

Ship To: SAMUEL SON & CO LTD
S.S.M.Q.
21525 CLARKE-GRAHAM
BAIE D'URFE H9X 3T5 QC

Item Description
Q.063 IN TK (+0.0000 -.0035) X 48.0 IN W (+.125 -
.125) X 144.0 IN LN (+.15625 -.15625) CAT D 126886 (N) A/T 6061-
T6 FLAT SHEET FOR DISTRIBUTORS TOLERANCE
GUARANTEED. AMS4027 REV N ANS1H35.2 REV 2009 EXC_MRK ASME-SB-
209 REV 10 EXC_MRK ASTMB209 REV 07
((MARKED)) KRAFT PAPER INTERLEAVED
MAX GROSS SKID WGT: 4750 LB QUAN TOL +/-
20 % CQR D126886 REV 40 CUST REQ 11-02-
26 *** W/E 11-03-05 ***

Num	Package Ticket	Lot	Weight	Quantity	UOM	Inspector Clock Numbers
1	280928	517443	3948	96	PC	27695 46964
2	280930	517443	3916	96	PC	27695 46964
3	280939	517443	3451	85	PC	27695 46964
			11315	277		

Notes for CQR: D126886.40
PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS4027 REV N ALSO MEET THE REQUIREMENTS OF AMS-QQ-A-250_11 ORIGINAL REVISIO N DATED 1997-08-01.

CQR: D126886.40 -Specification Limits

UTS	TYS	EL4D
KSI	KSI	PCT
Max		
Min 42.0	35.0	10

Chemical Composition

SI	FE	CU	MN	MG	CR	ZN	TI	Other Each	Other Total	Aluminum
Max 0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.15	
Min 0.40		0.15		0.8	0.04					

Alloy 6061
Lot: 517443 - Mechanical, Physical, Metallography, Quantometer Results

UTS	TYS	EL4D
KSI	KSI	PCT
No-> Test 11	48.8	43.7
		10.3



CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS
Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.
Per:

Malcolm Murphy
Director of Manufacturing Davenport Works

Kenton P. Young
Quality Assurance Manager

1216348 0
Ship Date B.L. No. Invoice No. Alcoa No. Item Page 2
2011-03-02 5721205 00000 1000261613-3 DCE-61613-3
P.O. No./Govt Contract No. Customer Alcoa Item
C63283 Ln#: 3 SAMUEL SON & CO LT G041015421R12

Lot: 517443

- Mechanical, Physical, Metallograpy, Quantometer Results (cont.) -----

48.8 /	43.5 /	10.8 /
48.8 /	43.8 /	11.5 /
48.7 /	43.8 /	11.5 /
48.9 /	43.6 /	10.9 /
48.9 /	43.5 /	11.4 /
49 /	44.1 /	11 /
49.3 /	43.8 /	10.5 /
49.1 /	44.1 /	10.5 /
49.3 /	44 /	10.9 /
49.1 /	44.1 /	11 /

Cast Number Chemical - OES SI / FE / CU / MN / MG / CR / ZN / TI /
11S00173 Actuals 0.63 0.5 0.26 0.05 1.0 0.20 0.01 0.02

This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States

